Work Order ID 113448 \*113448\* Page 1 February-14-14 1:18:25 PM Item ID: Accept D350-591-312 \*N900040100\* Setup Start **Revision ID:** Stop **Item Name:** Heli-Access-Step™ RH \*9\* **Start Date:** 14/02/2014 Start Qty: 2.00 **Cust Item ID: Required Date:** 21/02/2014 **Req'd Qty: 2.00** \*9\* **Customer:** Reference: **RE-WORKED TO CHANGE 002** Start Run **Process Plan:** Date: 14-02-14 Tooling: Approvals: Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Qty Qty Number Stamp Code Draw Nbr **Revision Nbr** D3272 Rev B 290 0.00 \*290\* Packaging 0.00 Memo Packaging PULL FROM STOCK D350-591-312 B 109339 (X2) ADD DSI 9410-011 (X1 PER KIT)

300

QC4- 100% Inspect kits for completeness

TO MAKE INTO CH. 002

0.00

<u>\*</u>300\*

Memo

. . . .

DAS 6 14-2-19

(2)

-89

Quality Control

0.00

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DQA: Date:						- ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~									٠				
QA Closed:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only  Work Order update only													
						DISPOSITION			AGAINST DEPARTMENT/PROCESS										
Work Order:						DISPOSITION			AGAINS	PROCESS									
Part No.					Rework			Skid-tube Crosstube	e	]	Water Jet		Engineering						
Part N	٠. ما					Scrap		1	Machining Small Fal	b	1	d. Eng. Coor.		Quality					
						Use-as-is		Thern	noforming Finishin	~—	Rec/Sto	e/Packaging	ᅴ	Other					
NCR N	۱o					Suspected Unapproved Large Fab Comp				e	j	Supplier	Ш						
Root	T				Desc	ription of work order update	<u>ا                                     </u>	Initial	Action		Sign &		П		•				
Cause		Date	Step	Qty		or non-conformance		nief Eng	Description	Description		Verification	<u>ا</u>	QC inspector					
Design		•																	
Doc/Data																			
Equip/Tooling																			
Handling/Pre																			
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Landi	ng G	ear			_	General		-		_	-	•			>				
	Ш	Bending		,		Bend		Folio/F	Program		Outside Dim	ensions	Ш	Pressure/Forced					
	Centre Not Concentric					BOM/Route		Grain			Over/Under tolerance			Set-up	•				
	Cracks					Broken/Damage/Defect		Hardwa	are	L	Part Incorrect		Ш	Temperature/Cure					
	Crimp/Kink/Ripple/Wave					Burrs	L	Inspect	ion Incomplete/Unqualified		Part Lost/Missing			Weld					
	Cracks					Contamination		Instruct	tions Incomplete/Unclear	L	Part Moved			Wrong Stock Pulled					
	Crushing				Countersink		Misalig	gned/off center		Positioned V	Vrong								
	Heat Treat				Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other						
		Inspectio	n Strip in	Tube		Drawing		Misrea	d						_				
	$\square$	Marks/Ch	natter			Drill Holes		Off-set							_				
,		Turning S	equence			Finish		Out of	Calibration										
	Wave/Twist in Tube					Fit/Function		Out of	Saguence										

Wor	k O	rder	ID	113448
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Quality Control

\*113448\*

Page 2

February-14-14 1:18:25 PM Accept Item ID: D350-591-312 \*N900040100\* Setup Start **Revision ID:** Stop **Item Name:** Heli-Access-Step™ RH \*9\* **Start Date:** 14/02/2014 Start Qty: 2.00 **Cust Item ID: Required Date:** 21/02/2014 **Req'd Qty:** 2.00 \*9\* **Customer:** Reference: **RE-WORKED TO CHANGE 002** Start Run **Approvals:** Process Plan: Date: \_\_\_\_\_ Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Accept Reject Reject Insp. **Work Center ID Description Run Hours** Qty Qty Number Stamp Code 310 0.00 \*210\* 14-2-19 & Packaging Memo PARKAGE UNDER NEW BATCH NUMBER 113448 Packaging 320 QC21- Final Inspection - Work Order Release 0.00 - <u>fl. 14-02-20</u> \*4200\* OC 0.00 Memo

DQA:		Date:												
					WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:		Date:		1	Work Order update only									
Work Orde	r:				DISPOSITION									
			·		Rework			Skid-tube Cross	stube	1	Water Jet	Engineering		
Part N	0.				Scrap	1			Machining Small Fab			Quality		
					Use-as-is		Therr	noforming Fini	shing	Rec/Stor	e/Packaging	Other		
NCR N	o			····	Suspected Unapproved		Large Fab Composi							
Root				Desci	ription of work order update		Initial	Action		Sign &				
Cause	Date	Step	Qty		or non-conformance		ief Eng	Description		Date	Verification	QC Inspector		
Design														
Ooc/Data			l											
quip/Tooling														
landling/Pre														
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Operator														
Offset/Setup														
Process	_													
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ransport														
Jnapproved	]	L	1	1		<u>ΕΛ1</u>	III T CA	I TEGORY		1	<u> </u>			
Landir	g Gear				General	17	OLI CA	ILOOKI						
[	Bending				Bend		] Folio/F	Program	Г	Outside Dim	ensions [	Pressure/Forced		
Ì	Centre No	ot Conce	ntric		BOM/Route	H	Grain			Over/Under	<u> </u>	Set-up		
ļ	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	<u> </u>	Temperature/Cure		
ľ	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified	d	Part Lost/Mi	ssing	Weld		
Ī	Cuffs				Contamination		1	tions Incomplete/Unclear		Part Moved	·	Wrong Stock Pulled		
Ī	Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong	_		
	Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other		
	Inspectio	n Strip in	Tube		Drawing		Misrea	d						
[	Marks/Ch	natter			Drill Holes		Off-set							
	Turning S	equence			Finish		Out of	Calibration						
	Wave/Tw	ist in Tul	oe		Fit/Function		Out of	Sequence						

February-14-14 1:19:03 PM

Work Order ID: 113448

\*113448\*

Parent Item:

D350-591-312

\*D350-591-312\*

Parent Item Name: Heli-Access-Step<sup>TM</sup> RH

**Start Date:** 14/02/2014

**Required Date:** 21/02/2014

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev: A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1

JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

IPP Rev:D

fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-591-312		Manufactured	No				Each	2.0000		2			
*D350-59	1-312*								**		NA		

Heli-Access-Step™ RH

<b>Location</b>	Loc Qty	Loc Code	
FG	1		
39411	1		
HALL	1		
112718	1		

DSI 9410-011 1 Per kit [2]

(13447

DQA:		Date:												
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only  Work Order update only									
ZA Closca.		Date.				1	1		·	voik Oldel d	puate only	<u> </u>		
Work Orde	r:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS			
	• "		-		Rework	]		Skid-tube	Crosstube		Water Jet	Engineering		
Part No	0.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
					Use-as-is	1		noforming	Finishing	<b>⊣</b>	re/Packaging	Other		
NCR N	o				Suspected Unapproved	]		Large Fab	Composite	]	Supplier			
Root	<del></del>	1	I	Desc	ription of work order update		Initial	Ac	ction	Sign &	1			
Cause	Date	Step	Qty		or non-conformance		nief Eng		cription	Date	Verification	QC Inspector		
Design		<del>                                     </del>					<u>U</u>							
Doc/Data		Ì	1				,							
quip/Tooling														
landling/Pre				•				:						
Material [												1		
Operator														
Offset/Setup								٧						
Process														
Supplier														
Training						1								
Transport					•	l			·					
Jnapproved														
						FA	ULT CAT	TEGORY						
Landin	g Gear				General	_	_					_		
· L	Bending				Bend		-1	rogram	L	Outside Din	nensions	Pressure/Forced		
1_	Centre Not Concentric				BOM/Route	_	Grain		·	Over/Under	tolerance	Set-up		
1	Cracks				Broken/Damage/Defect		Hardwa		<u> </u>	Part Incorre	<del></del>	Temperature/Cure		
-	Crimp/Kink/Ripple/Wave				Burrs	_	-i	on Incomplete/U	· · -	Part Lost/M		Weld		
_	Cuffs			<u> </u>	Contamination	<u>_</u>	-	ions Incomplete/		Part Moved		Wrong Stock Pulled		
_	Crushing			<u> </u>	Countersink	$\vdash$	<b>⊣</b> ~	ned/off center	<u> </u>	Positioned	· -	, 7		
_	Heat Trea				Cut Too Short	_	Mislabe		L	Power Loss,	'Surge	Other		
-	Inspectio	•	Tube	_	Drawing	$\vdash$	Misread	d						
-	Marks/Ch			<u> </u>	Drill Holes		Off-set							
	Turning S	•		<u> </u>	Finish	$\vdash$	-1	Calibration						
	W/ave/Tu	ist in Tub	10	- 1	Fit/Function	1	IOut of 9	Saguence						